



Date: Wednesday, 16/07/2008 9:19:14 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE TUBE

Job Number: 40555

Part Number: PB6743001239

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PB6743001225

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bushing

batch: B 40555

SP 08-07-28. (12x)

7.0 PB6743001223

Square Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Square Cap

batch: B 40555

SP 08-07-28 (3x)

8.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg

SP 08-07-28 (3x)

9.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush

2- deburr

SP 08-07-28 (3x)

10.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

SP 08-07-28 (3x)

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 08-07-28 (3x)

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WIP

SP 08-07-28 (3x)

13.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SP 08-08-07 (3)  
MF 08-08-06

Date: Wednesday, 16/07/2008 9:19:14 AM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SQUARE TUBE		
Job Number	: 40555					
Estimate Number	: 13421					
P.O. Number	:			Part Number	: PB6743001239	
This Issue	: 16/07/2008		S.O. No. :	Drawing Number	: B6743001 P.6/ P.21	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: B1	
Previous Run	:			Material	:	
Written By	:			Due Date	: 23/07/2008	
Checked & Approved By	: MF 08-07-16			Qty:	3	
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec			Um:	Each	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6TS1000W125	6061T6 SQ TUBE 1.00X.125	
		Comment: Qty.: 1.8375 f(s)/Unit Total : 5.5125 f(s) 6061T6 SQ TUBE 1.00X.125 batch: 7108626	SAD 08/07/17
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1  1- cut to length as per dwg 2- make a 0.090" chamfer on both ends of tube 3- deburr	SAD 08/07/17
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	SAD 08/07/17
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE 1- drill holes as per dwg 2- make a 0.090" chamfer (100 degree) on both side of the 4 holes 3- deburr	51 08/07/26
5.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	SAD 08/07/28